

Work Order ID 67520 - 2



Page 1

Monday, March 28, 2011 7:24:58 AM

Item ID: D3183-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 3/28/2011 Start Qty: 50.00

Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 50.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn D3183-9 Cap as per Folio FA388 Deburr

ml 11-3-28

50

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ml 11.3.28

50

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

ml 11/3/28

50

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Page 2

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Customer:

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Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

0.00

0.00

*Press on
w/o 67525**PID. D*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

MF 11-03-28.

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

*GA.**(12) MF 11-03-28.
STOCK UNDER.
D3183-9*

Work Order ID 67520

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Item ID: D3183-045

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Setup Start



Revision ID:

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Item Name: Bearing Assembly

Start Date: 3/28/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 4/03/28

Picklist Print

Page 1

Monday, March 28, 2011 7:24:54 AM

Work Order ID: 67520



Parent Item: D3183-045



Parent Item Name: Bearing Assembly

Start Date: 3/28/2011

Required Date: 3/30/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A ☐ 04.02.18 ☐ New issue ☐ KJ/DS ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3183-5		Manufactured	No			110	Each	23.0000	1	50			
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Bearing

Location

Loc Qty

Loc Code

ST236

23

67065

23

MDELNR1.000		Purchased	No			130	f	14.0000	0.0333	1.752632			
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Delrin Round Bar 1"

Location

Loc Qty

Loc Code

MAT055

14

116266

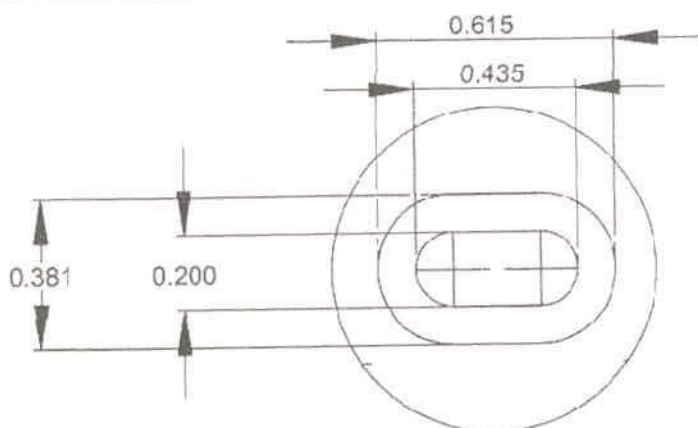
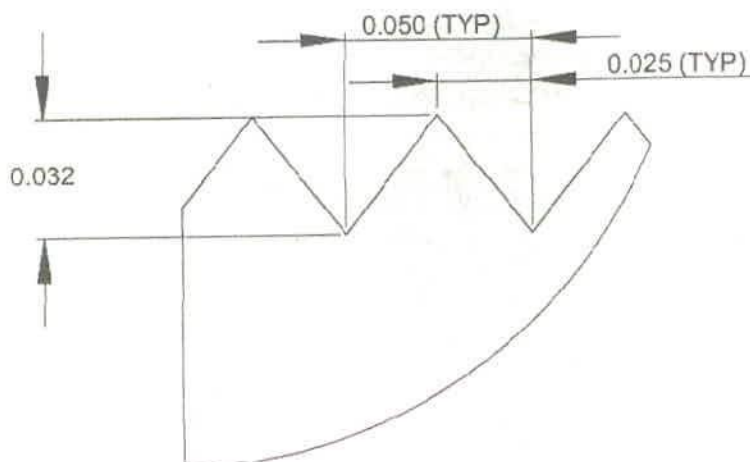
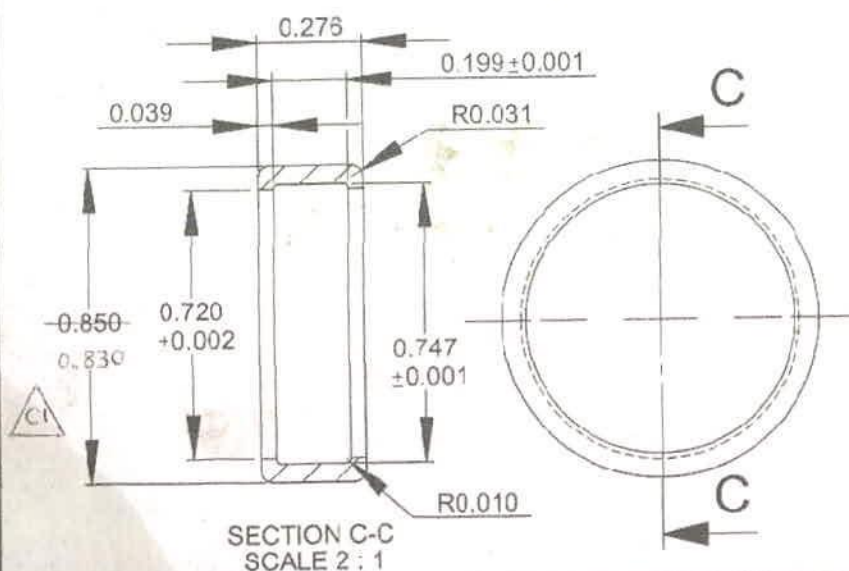
14

ml 1.3.28

1.666"

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**DETAIL A (2 : 1)****RELEASED**
04-03-01**DEO ATTACHED****DETAIL B (20 : 1)****D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Put D3183-9 in stock # <u>67520</u> . part number	MF				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries